

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024222**Date Inspected:** 17-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** See Below**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Summary of Items Observed: On this date Caltrans OSM Quality Assurance (QA) Inspector, Mike Hasler was present during the times noted above for observations and testing relative to the work being performed.

**Trial Assembly**

OBG Segment Name: 13AE to 13BE/ Trial Assembly

During Quality Assurance observations of the fabrication at OBG 13AE to 13BE, this Quality Assurance Inspector (QA) observed ZPMC welder welding unidentified material inside the weld joint on 3 deck panel I-rib stiffener splice joints. The deck panel I-rib material is identified as HPS-485-WT2. The material is not shown on the approved shop drawings. The weld joints are Complete Joint Penetration (CJP) welds joining OBG segment 13AE deck panel stiffeners identified as RS3112C and RS3112E (QTY of 2), to OBG segment 13BE deck panel stiffeners identified as RS3172A, RS3172B and RS3176A. The weld joints are identified as OBE13G-001, 004 and 007. The base materials are Non Seismic Performance Critical Material (Non-SPCM).

This QA inspector informed ZPMC QC inspector Wang Li Yang of the welding violation. This Caltrans QA inspector generated a Quality Assurance-Incident Report for the welding violation. See Quality Assurance-Incident Report, dated 05-17-11 for additional information. ZPMC QC inspector is identified as Mr. Li Ping.

**UT Inspection**

This Caltrans QA inspector received ZPMC non-destructive test (NDT) NWIT #09163 Item 15, 16, 17, 18 for Trial Assembly OBG segment 13AE. This QA Inspector performed verification Ultrasonic Testing (UT) inspection after ZPMC had performed their UT inspection of the following locations;

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## WELDING INSPECTION REPORT

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Item 15; SEG3007AE-093

Item 16; SEG3007V-509, 511, 513, 517, 519, 521, 405

Item 17; SEG3007Y-425, 427, 429, 431, 433, 435, 437

Item 18; SEG3007X-479, 491, 485, 487, 496

At the time of the verification it was noted that the above component appeared to be within compliance of the contract documents. See Caltrans Ultrasonic Test Report (TL6027), dated 05-17-2011 for additional information.

The following digital picture illustrates QAUT inspection of typical welds.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



### Summary of Conversations:

"As noted within the contents of this report."

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact James Devey 15000026784, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hasler, Mike
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Quality Assurance Inspector
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<b>Reviewed By:</b>	Riley, Ken
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QA Reviewer
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